

Split 3
Work Order ID 135832-3

Friday, August 21, 2015 7:09:27 AM

135832

Page 1

Item ID: D2571
Revision ID:
Item Name: Saddle, Fwd, Out
Start Date: 8/21/2015 Start Qty: 8.00
Required Date: 8/21/2015 Req'd Qty: 8.00
Reference:
Accept *N9000040100*
Setup Start *NS1*
Stop *NS2*
Cust Item ID:
Customer:

Approvals: Process Plan: MLJ Date: AUG 21 2015 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2571	F								

100
100
HAAS 1
HAAS CNC vertical machine #1
HAAS CNC VERTICAL MACHINING #1
Memo
Program Batch No. 135832
Double check by: JHC
1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
3-Machine Step No 3 per Folio FA051 and inspect
DAS 08 9-89 16/03/12 12 1
DAS 40 9-89 16/03/15
DAS 44 9-89 16/01/07

110
110
Mill Conv
Conventional Milling Machine
CONVENTIONAL MILLING MACHINE
Memo
Machine keyway as per dwg D2571 & D2572
DAS 40 9-89 16/03/16 12 0
PTO →
Last page

240
241
242

243
244
245

Work Order ID 135832

Friday, August 21, 2015 7:09:27 AM

135832

Page 2

Item ID: D2571

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Saddle, Fwd, Out

Start Date: 8/21/2015 Start Qty: 8.00 *8*

Required Date: 8/21/2015 Req'd Qty: 8.00 *8*

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00	DAS 08 9-89	16/03/12		12	1		DAS 44 9-89 16/01/07
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	DAS 40 9-89	16/03/16		12			SL 16-3-17
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				12x	d	90	16/03/21

Hand
40
100

Work Order ID 135832

Friday, August 21, 2015 7:09:27 AM

135832

Page 3

Item ID: D2571

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Saddle, Fwd, Out

Stop *NS2*

Start Date: 8/21/2015 Start Qty: 8.00

8

Cust Item ID:

Required Date: 8/21/2015 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	White Gloss(Ref:4.3.5.1) per OSI005 4.3-Alum	0.00							
150	<i>m 133962</i>								
Powdercoat	Memo	0.01							
Powder Coating	START TIME: <i>11:20</i> OVEN TEMPERATURE: <i>320°</i> FINISH TIME: <i>11:50</i>								
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <i>ST397</i>	0.00							
170									
Packaging	Memo	0.00							
Packaging									

12 *16-03-28*

(12) *DAS 38 9-8c*
MAR 28 2016

12a *SP16-03-28*



Work Order ID 135832

Friday, August 21, 2015 7:09:27 AM

135832

Page 4

Item ID: D2571

Accept

N900040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: Saddle, Fwd, Out

Start Date: 8/21/2015 Start Qty: 8.00

8

Cust Item ID:

Required Date: 8/21/2015 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.01

Quality Control

ML5

MAR 30 2016

APR 3.28

Picklist Print

Friday, August 21, 2015 7:09:31 AM

Page 1

Work Order ID: 135832

135832

Parent Item: D2571

D2571

Parent Item Name: Saddle, Fwd, Out

Start Date: 8/21/2015

Required Date: 8/21/2015

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: 102.10.02Re-format; Change to Dwg Rev. D & incorporated D2572KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-007		Manufactured	No			100	Each	24.0000	1	8			
D6101-007													
Saddle Billet													

Location	Loc Qty	Loc Code
MAT041	16	
131095	1	
133547	15	
MAT044	8	
116083	1	
120494	7	

138056

135764

DAS
40
9-89

→ 140553

12
4 + 9

16/01/07

DART AEROSPACE LTD	Work Order: 135832
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. F	Page 1 of 1

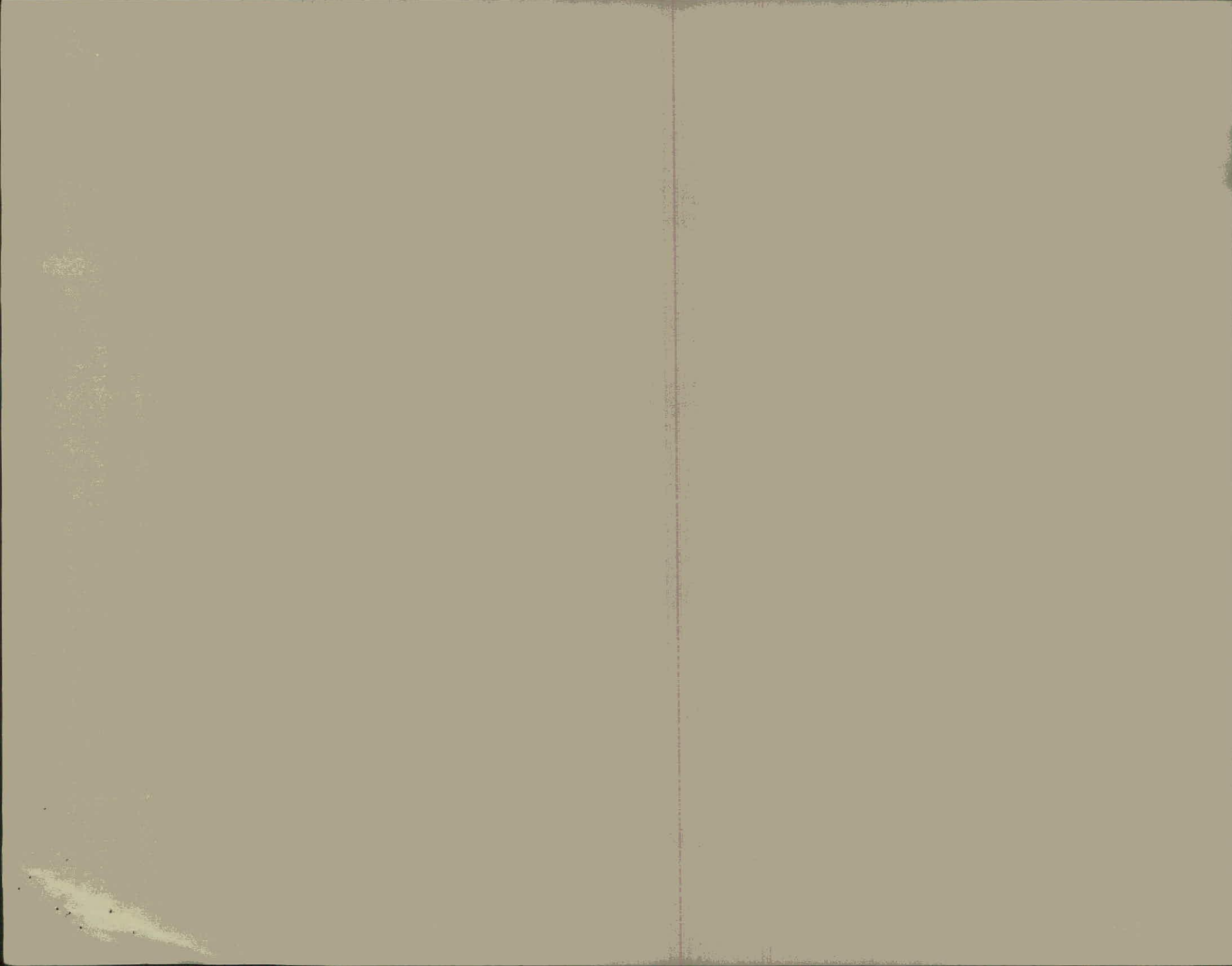
Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.434	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.004	8.004	8.000	8.003		
F	0.490	0.510		.500	.501	.500	.500		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.505	.505	.503	.503		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.573	.573	.571	.579		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.872	3.874		
P	0.115	0.135		.130	.130	.130	.130		
Q	0.115	0.135		.125	.126	.125	.126		
R	0.240	0.260		.251	.250	.250	.251		
S	0.115	0.135		.123	.125	.122	.123		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.238	.240	.240	.239		
W	0.115	0.135		.116	.121	.119	.119		
X	0.308	0.313		.312	.312	.311	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.364	.363	.364	.364		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.629	.629	.629	.627		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.248	.250	.250	.249		
AE	1.375	1.395		1.390	1.3875	1.3875	1.3875		
AF	0.115	0.135		.125	.125	.125	.125		
AG	0.240	0.280		.255	.255	.255	.255		
AH	0.240	0.260		.246	.247	.249	.246		
AI	2.000	2.020		2.005	2.003	2.003	2.0035		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject				✓	✓	✓	✓		

Measured by: 44
Date: 16/01/07

Audited by: JL
Date: 16-3-17

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	



DART AEROSPACE LTD	Work Order: 135832
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				5	6	7	8		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.003	8.004	8.000	8.000		
F	0.490	0.510		.501	.502	.499	.499		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.504	.505	.505	.504		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.573	.573	.572	.572		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.130	.130	.130	.130		
Q	0.115	0.135		.126	.125	.125	.125		
R	0.240	0.260		.251	.250	.250	.251		
S	0.115	0.135		.123	.123	.122	.123		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.240	.241	.241	.240		
W	0.115	0.135		.119	.118	.119	.119		
X	0.308	0.313		.311	.311	.311	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.364	.364	.364	.364		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.629	.627	.629	.629		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.251	.251	.250		
AE	1.375	1.395		1.389	1.3865	1.387	1.3875		
AF	0.115	0.135		.125	.125	.125	.125		
AG	0.240	0.280		.255	.255	.255	.255		
AH	0.240	0.260		.246	.246	.248	.246		
AI	2.000	2.020		2.0045	2.002	2.002	2.003		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject
DAS

Measured by:	44
Date:	9-89 16 p1/11

Audited by:	JL
Date:	16-3-17

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order: 135832
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				9	10	11	12		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.002	8.000		
F	0.490	0.510		.500	.501	.504	.504		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.375	.378	.378	.378		
I	0.490	0.510		.503	.500	.499	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.569	.564	.565	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.130	.130	.130	.130		
Q	0.115	0.135		.125	.124	.124	.124		
R	0.240	0.260		.251	.251	.250	.250		
S	0.115	0.135		.122	.120	.129	.129		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.240	.238	.238	.238		
W	0.115	0.135		.119	.119	.117	.119		
X	0.308	0.313		.311	.310	.310	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.364	.363	.363	.363		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.629	.625	.628	.628		
AC	0.053	0.073		.063	.063	.060	.060		
AD	0.240	0.260		.250	.250	.248	.246		
AE	1.375	1.395		1.385	1.390	1.392	1.392		
AF	0.115	0.135		.125	.130	.130	.130		
AG	0.240	0.280		.255	.280	.280	.280		
AH	0.240	0.260		.246	.248	.248	.248		
AI	2.000	2.020		2.0035	2.005	2.0045	2.007		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

Measured by:	44
Date:	16/01/12

Audited by:	JL
Date:	16-3-12

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order: 135832
Description: Saddle, Fwd Outboard		Part Number: D2571
Inspection Dwg: D2571 Rev. F		Page 1 of 1

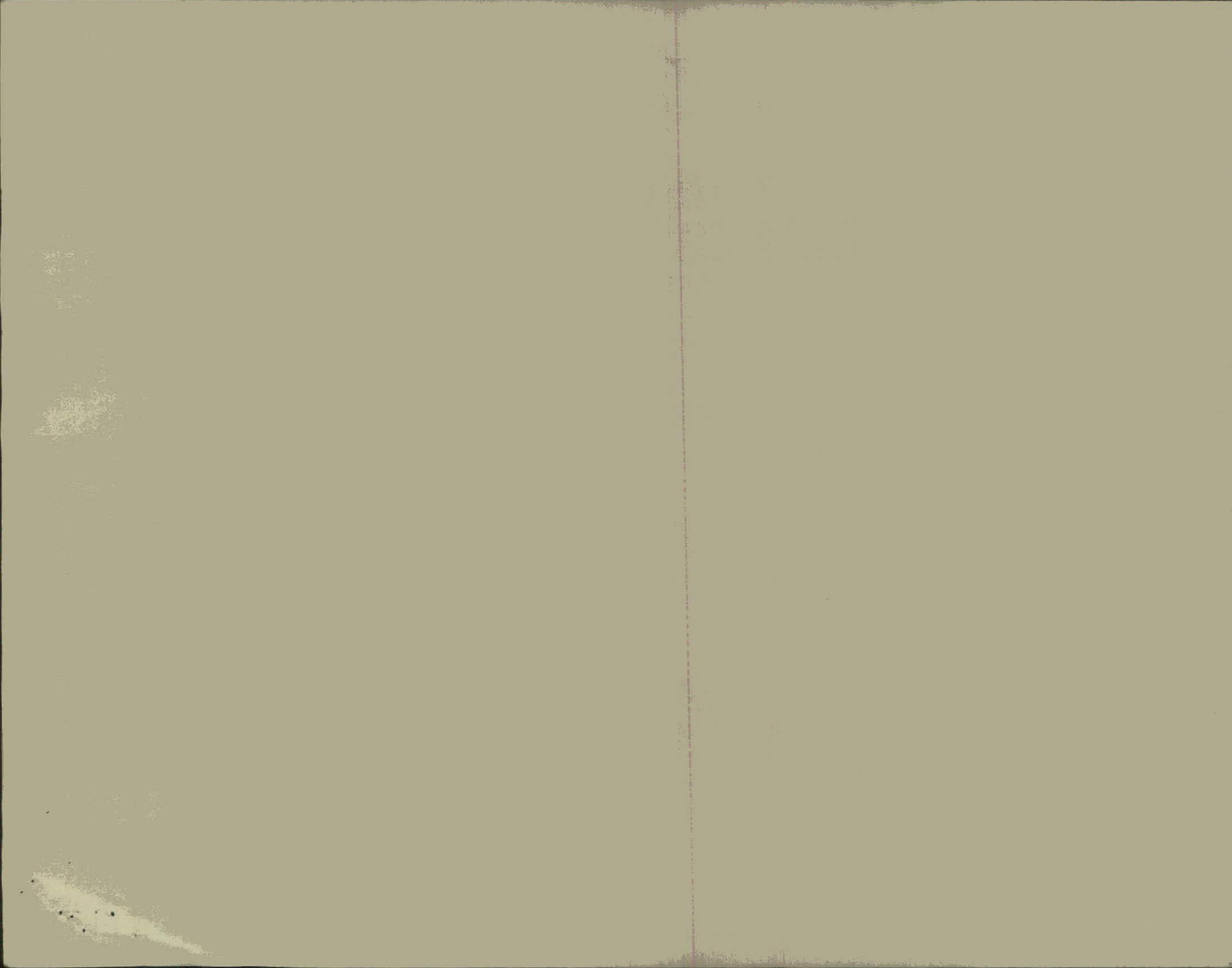
Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				13	14	15	4		
A	0.438	0.443		0.438					
B	1.745	1.755		1.750					
C	3.495	3.505		3.500					
D	1.745	1.755		1.750					
E	7.990	8.010		8.000					
F	0.490	0.510		0.501					
G	0.257	0.262		0.258					
H	0.375	0.380		0.377					
I	0.490	0.510		0.500					
J	1.174	1.184		1.179					
K	0.558	0.578		0.614					
L	1.174	1.184		1.179					
M	1.490	1.500		1.495					
N	2.495	2.505		2.500					
O	3.869	3.879		3.874					
P	0.115	0.135		0.130					
Q	0.115	0.135		0.123					
R	0.240	0.260		0.250					
S	0.115	0.135		0.128					
T	0.178	0.198		0.188					
U	2.940	2.980		2.960					
V	0.230	0.250		0.238					
W	0.115	0.135		0.121					
X	0.308	0.313		0.311					
Y	0.760	0.765		0.760					
Z	0.352	0.372		0.361					
AA	0.470	0.530		0.500					
AB	0.615	0.635		0.625					
AC	0.053	0.073		0.063					
AD	0.240	0.260		0.248					
AE	1.375	1.395		1.390	1.388				
AF	0.115	0.135		0.135					
AG	0.240	0.280		0.280					
AH	0.240	0.260		0.245					
AI	2.000	2.020		2.005	2.0013				
AJ	0.023	0.043		0.035					
Accept/Reject				✓					

Measured by:	
Date:	

Audited by:	JK
Date:	16-3-17

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	KA



(last split)

DART AEROSPACE LTD	Work Order:	135832
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. F		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		0.500	0.500	0.500	0.500		
G	0.257	0.262		0.258	0.258	0.258	0.258		
H	0.375	0.380		0.377	0.377	0.377	0.377		
I	0.490	0.510		0.500	0.500	0.500	0.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.568	0.568	0.568	0.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.135	.135	.135	.135		
Q	0.115	0.135		.123	.123	.123	.122		
R	0.240	0.260		.250	.251	.251	.242		
S	0.115	0.135		.121	.120	.121	.122		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.236	.238	.230	.237		
W	0.115	0.135		.116	.115	.117	.119		
X	0.308	0.313		.311	.311	.311	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.362	.362	.362	.362		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.627	0.627	0.627	0.627		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		.245	.245	.245	.247		
AE	1.375	1.395		1.385	1.385	1.385	1.385		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		0.240	0.240	0.240	0.240		
AH	0.240	0.260		.250	.250	.250	.250		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.038	0.032	0.032	0.032		
Accept/Reject									

Measured by: <u>Ba</u>	DAS	DAS	Audited by: <u>Sh</u>
Date: <u>16/03/12</u>	08	40	Date: <u>16-3-12</u>
	9-89	9-89	

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By																																																									
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Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

(last split)

DART AEROSPACE LTD	Work Order:	135832
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. F		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	15	16	17	18		
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		0.500	0.500	0.500	0.500		
G	0.257	0.262		0.258	0.258	0.258	0.258		
H	0.375	0.380		0.377	0.377	0.377	0.377		
I	0.490	0.510		0.500	0.500	0.500	0.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.568	0.568	0.568	0.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.135	.135	.135	.135		
Q	0.115	0.135		.123	.123	.123	.123		
R	0.240	0.260		.249	.250	.250	.250		
S	0.115	0.135		.120	.121	.121	.121		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.236	.230	.237	.238		
W	0.115	0.135		.117	.116	.117	.117		
X	0.308	0.313		.311	.311	.311	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.362	.362	.362	.362		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
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AD	0.240	0.260		.243	.243	.244	.245		
AE	1.375	1.395		1.385	1.385	1.385	1.385		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		0.240	0.240	0.240	0.240		
AH	0.240	0.260		.245	.245	.245	.245		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.032	0.032	0.032	0.032		
Accept/Reject									

Measured by:	B.e	DAS	DAS
Date:	16/03/14	08	40
		9-85	9-89

Audited by:	SL
Date:	16-3-17

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																				
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DART AEROSPACE LTD	Work Order: 135 832
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. F	Page 1 of 1

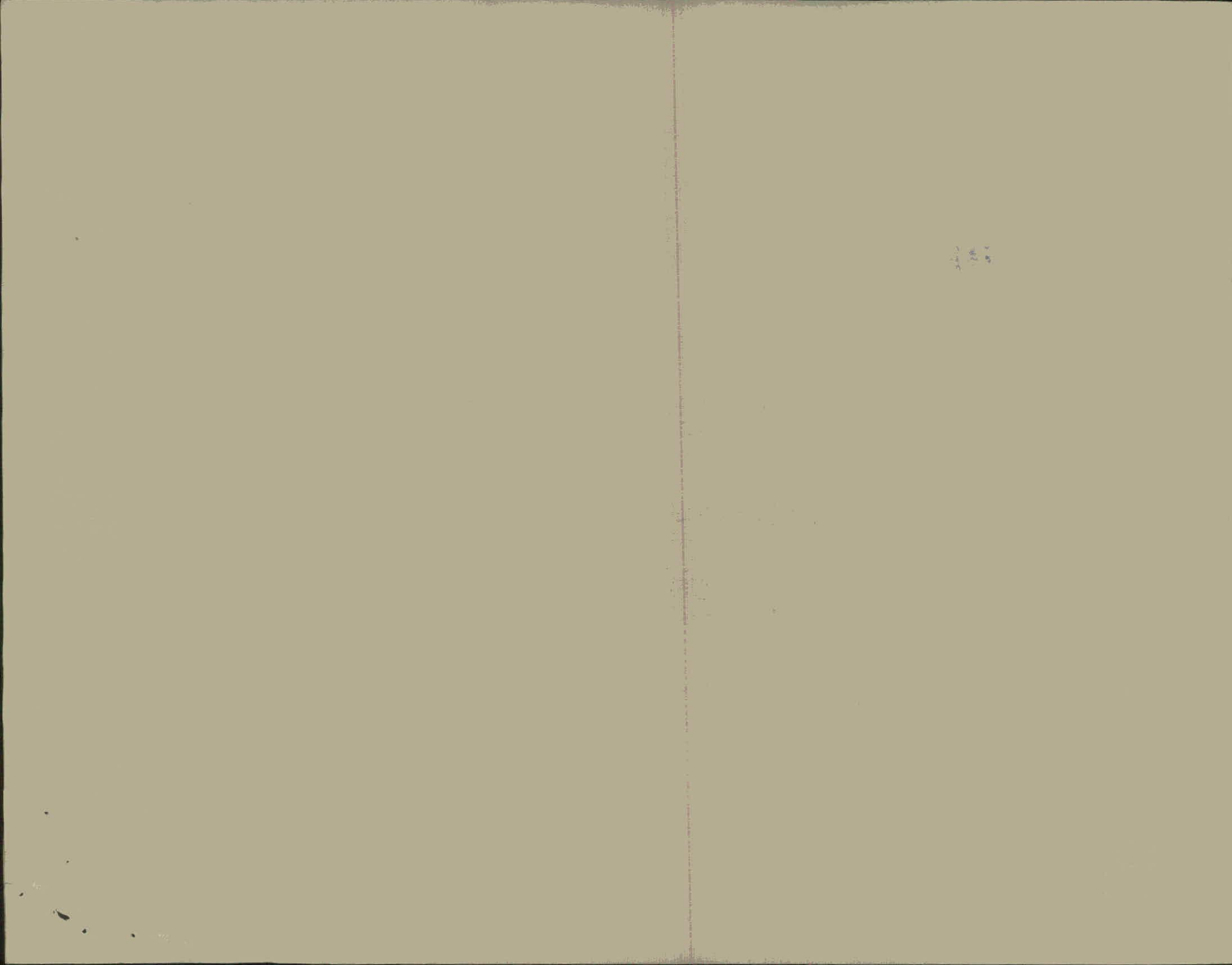
Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	19	210	811	112		
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Accept/Reject									

Measured by: DAS	16/03/16
Date: 40	

Audited by: SL	16-3-17
Date:	

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
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D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	



DQA:

Date: 16-03-10



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: 16/05/10

Work Order update only

Work Order: 135832		DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. D271		Rework ☒		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
NCR No. 16-5775		Scrap ☒		Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
		Use-as-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
		Suspected Unapproved ☐		Large Fab ☐	Composite ☐	Supplier ☐			
Date: 16-03-17		Step #: 100		QTY Effective: ①			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition			Completed By		
When the 1" e-m is finishing the skid edge it leaves a big chunk before the last pass so at the last pass that same chunk got kicked in between the skid bore and tooling plate resulting as chamfering the island .085" deep and engraving DART Logo .025" deep				→ A 1" rougher was added before 1" e-m to solve the problem Program has been updated SCRAP & REPLACE			16/03/17		
							Lead hand / Supervisor Approval Verification		
							DAS 9 9-89 16-03-17		
							QC / QA Coordinator Approval		
							DAS 9 9-89 16-03-17		
Root Cause				FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
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Misidentified ☐	Past Due ☐	OTHER :							

